

Page 1

May-11-12 8:16:16 AM

Setup Start *NS1*

Stop *NS2*

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84387

84387

Page 2

May-11-12 8:16:16 AM

Item ID: D3152-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 11/05/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 25/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00				4			SB 13/05/12
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SmB B.221		4			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		AB13.225	

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NOTE: Date & initial all entries

Work Order ID 84387

84387

Page 4

May-11-12 8:16:16 AM

Item ID: D3152-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 11/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: **ST030** 0.00

190

Packaging

Memo

0.00

Packaging

4/1

SP
13-2-27

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

13/2/28

MLJ 13-02-28

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May-11-12 8:16:19 AM

Page 1

Work Order ID: 84387

84387

Parent Item: D3152-2

D3152-2

Parent Item Name: Bracket

Start Date: 11/05/2012

Required Date: 25/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.05.10 DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

376.3800

0.04

0.168421

M2024T3S 063

**

2024-T3 .063 sheet

Jm 12-6-15

Location

Loc Qty

Loc Code

MAT022

376.38

119916

141.38

121197

235

117392

117392

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NOTE: Date & initial all entries



DESIGN #	DRAWN BY D	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3152	REV. B SHEET 1 OF 2
DATE 04.10.18		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.24	NEW ISSUE	
B	04.10.18	ADD PART MARKING & RTV 732 BLACK	

RELEASED
04/11/23

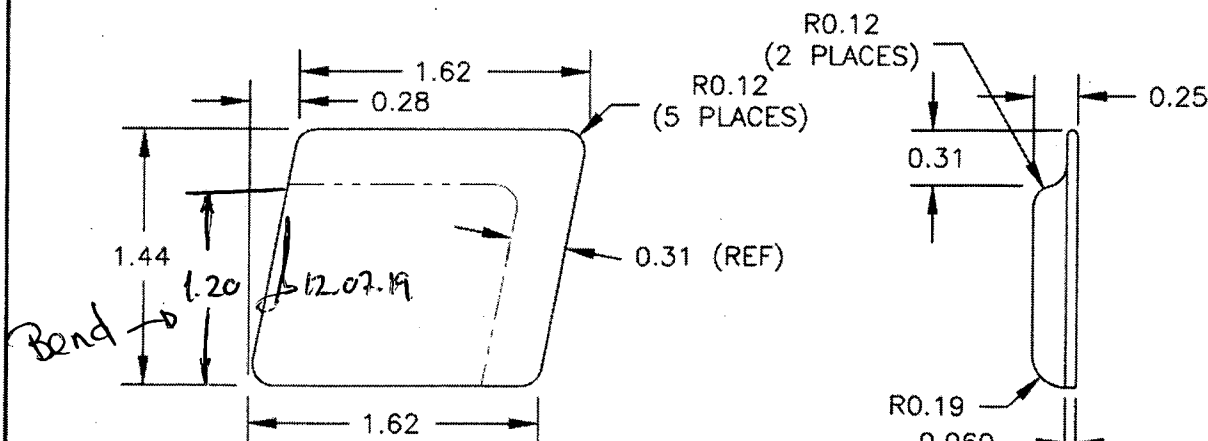
D3152-041 BRACKET ASSEMBLY
D3152-042 BRACKET ASSEMBLY

IDENTIFY WITH DART P/N
USING FINE POINT PERMANENT
INK MARKER

D3152-3 (-041)
or D3152-4 (-042)

D3152-1 (-041)
or D3152-2 (-042)

BOND D3152-3/-4(OPP) SEAL TO
D3152-1/-2(OPP) BRKT USING
RTV 732 CLEAR (A/R)
OR RTV 732 BLACK (A/R)



D3152-3 SEAL (SHOWN)
D3152-4 SEAL (OPPOSITE)

1. D3152-3 REPLACES PREMIER P/N B30-23000-243
D3152-4 REPLACES PREMIER P/N B30-23000-244
2. MAKE D3152-3 PER TOOL # B30-23000-243T
MAKE D3152-4 PER TOOL # B30-23000-244T
3. MATERIAL: RTV 732 BLACK
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87589MCS
12/05/11

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Dart Aerospace Ltd

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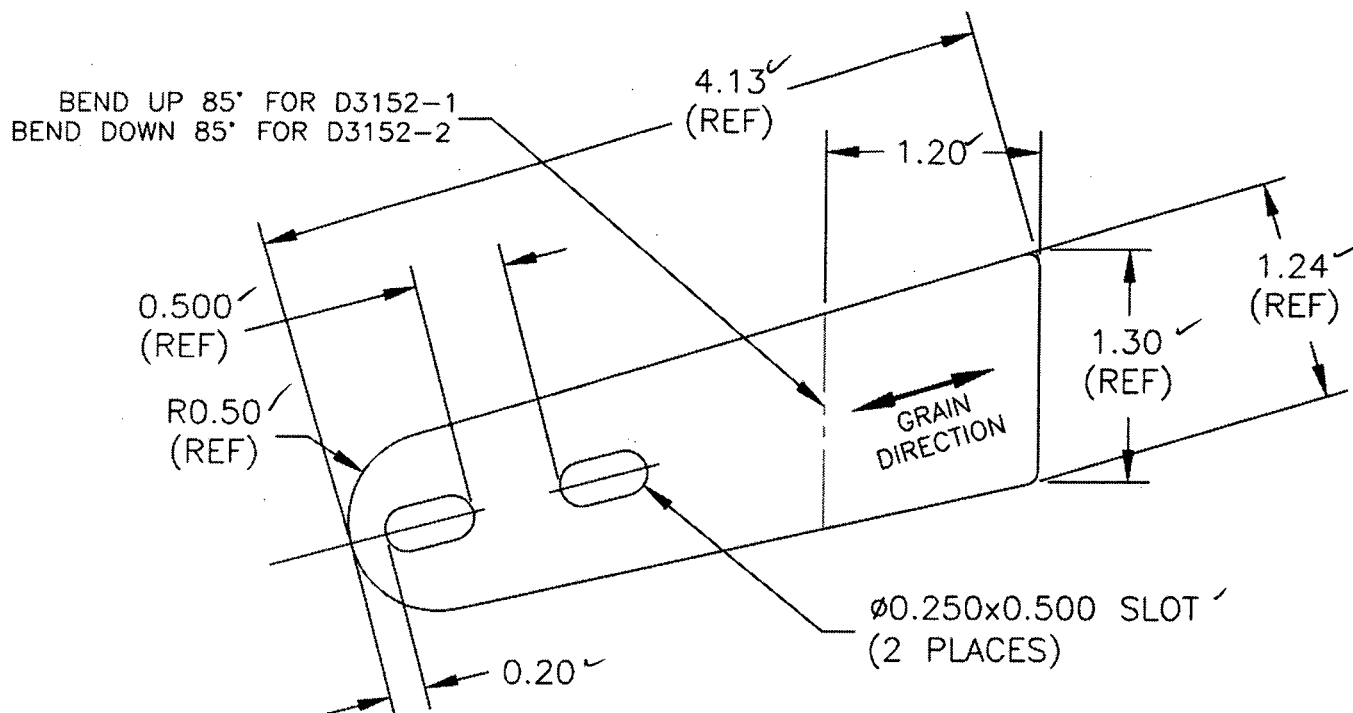
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3152	REV. B SHEET 2 OF 2
DATE 04.10.18		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED
04.11.23



D3152-1/-2 BRACKET

1. D3152-1 REPLACES PREMIER P/N B30-23000-223
D3152-2 REPLACES PREMIER P/N B30-23000-224
2. MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF DART SPEC. M2024T3S.063)
3. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES
6. BREAK ALL SHARP EDGES 0.005 TO 0.010
7. MACHINE PER DWG FILE "D3152-B2.DWG"

24388

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